

5/07

DART AEROSPACE LTD	Work Order:	22191
Description: Webbing Tidy	Part Number:	D3215-3
Dwg: D3215 Rev. ^C A page 3 R# 04.03.24	Qty:	63 60
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Note: To be made in multiples of 10.	HA	05.01.14	60
2	MV	Cut blank: 2.562" x 0.880" Grain along 2.562" Material: 5052-H32 (QQ-A-250/8) 0.040" thick R# 04.01.12 (M5052H32S.040) Identify for D3215-3A Batch: M15982	J	05-01-19	70
3	MV	Machine D3215-3A as per Folio FA376 and dimensions Use Stack of 10 Identify as D3215-3A	Ep	05/01/19	70 70
4	QC2	Inspect parts as they come off the CNC machine	Ep	05/01/19	70 70
5	MV	Deburr for measurement	Ep	05/01/19	70 70
6	QC8	Second check	mk	05/01/19	70
7	GA	Cut blank: 2.130" x 0.530" Material: 5052-H32 (QQ-A-250/8) 0.040" thick (M5052H32S.040) Identify as D3215-3B Batch: M15982	ED	05/01/24	70
8	GA	Deburr D3215-3A/-3B	SB	05/02/07	70
9	GA	Form D3215-3A as per Dwg D3215	Z	05.02.14	70
10	QC5	Inspect work to Step 9	NA	05/03/01	70 70
11	WA	Weld D3215-3 by joining D3215-3A and D3215-3B as per Dwg D3215 and QSI 004 Identify as D3215-3	CPL	05-03-01	63
12	WA	Grind flush	CPL	05-03-01	63
13	QC9	Inspect weld	AD	05/03/01	63
14	FP	Chemical Conversion Coat as per QSI 005 4.1	MM	05.03.09	63
15	FP	Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3	MM	05 03 10	63
16	QC3	Inspect Powder Coat	CL	05/03/11	63
17	ST	Identify and Stock	CL	05/03/11	63
18	AC	Cost / part 7.32	Sur	05.03.14	63
19	DC	Close W/O 6.87 Inspect Level 21	HA	05.03.18	63

PTO

Rev	Date	Change	Revised By	Approved
A	04.01.06	New issue	KJ/RF	CF

RELEASED
04.01.09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/03/01	11	7 scrap when welding first time welding	IB progrm	Destroy	05-03-01 CPK	IB 05-03-01	IB progrm	IB 05-03-01

Part No: D3215-3 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: [Signature] Date: 05/03/18

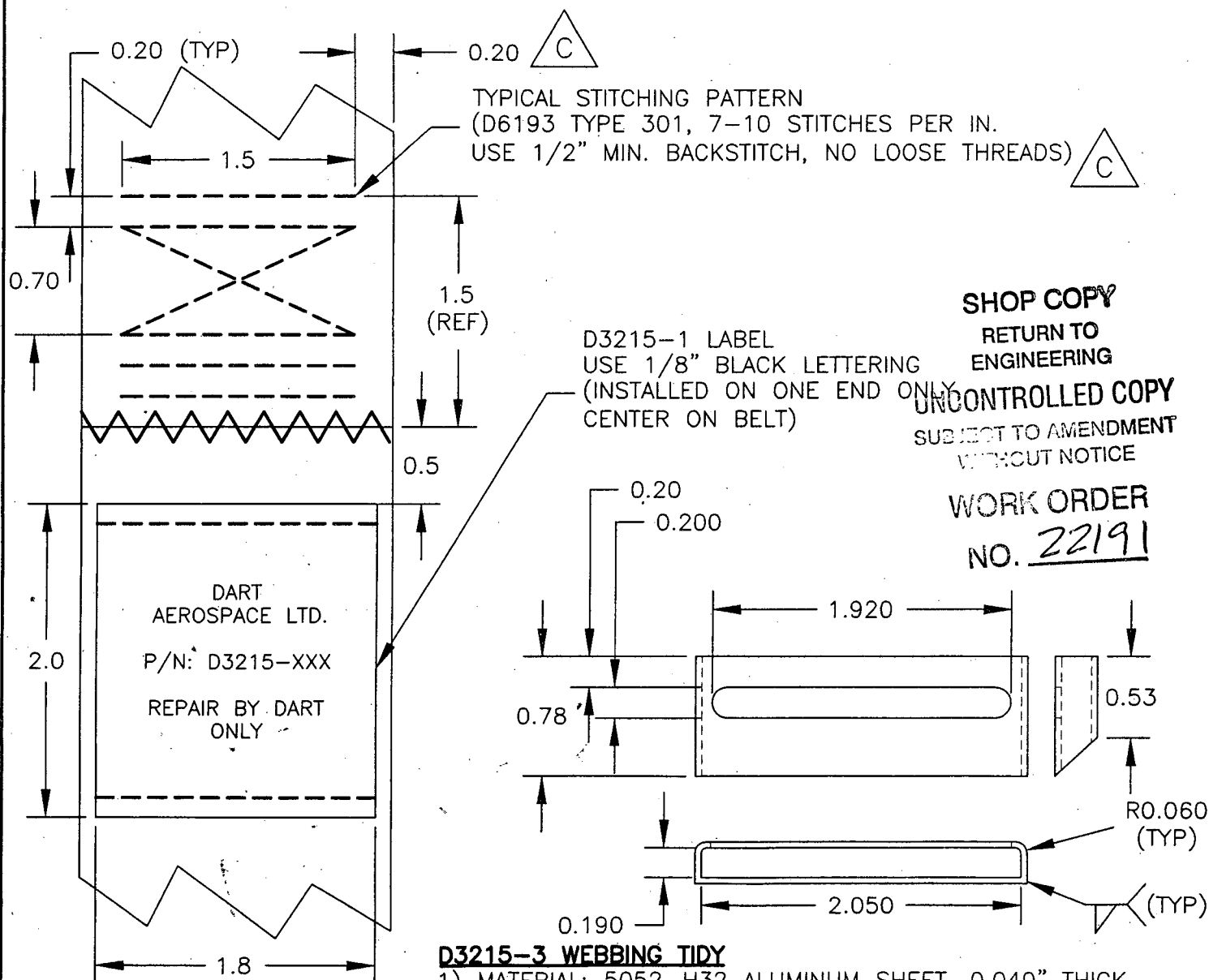
NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____



DESIGN gp	DRAWN BY gp	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3215	REV. C SHEET 3 OF 3
DATE 04.03.05	TITLE HARNESS ASSEMBLY		SCALE 1:1

VIEW A-A

XXX = 041 FOR D3215-041
XXX = 043 FOR D3215-043



D3215-3 WEBBING TIDY

- 1) MATERIAL: 5052-H32 ALUMINUM SHEET, 0.040" THICK
(REF DART SPEC. M5052H32S.040)
- 2) WELD PER DART QSI 004
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER
DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE
NOTED

RELEASED
04.03.08

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jan 12, 2005
01:18 pm

Work Order No. : 0022191
Project Name : D3215-3
Project For : WK507
Work Order Type : Main
Main WO Number :
House Part Number : D3215-3
Description : Webbing Tidy
Manufactured : Yes
Amount Req'd : 60
Amount Done : 0
Start Date : 01-12-05
Est Finish Date : 02-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00